REQ	UEST FOR O	QUOTATIONS	THIS REO [VIIS [115 NO	T A SMALL BUSINESS S	ET-ASIDE		PAGE	OF PAGES	
(THIS IS NOT AN ORDER)			THIS RFQ [X] IS [] IS NOT A SMALL BUSINESS SET-A		ET-ASIDE			10	
1. REQUES W911XK-06	T NO.	2. DATE ISSUED 13-Oct-2005	3. REQUISITION/PURCH REQUEST NO. W56MES-5280-3059	IASE	U.	ERT. FOR NAT. DEF. NDER BDSA REG. 2 ND/OR DMS REG. 1	RATING	ATING	
5a. ISSUED		13-001-2005	VV30IVIE3-3280-3039						
CONTRACTING DIVISION DETROIT DISTRICT, USAED, 477 MICHIGAN AVE DETROIT MI 48226					0. Di	6. DELIVER BY (Date) SEE SCHEDULE			
					7. DELI	VERY			
				[X] FOB] OTHER		
	FORMATION C LAWRENCE	ALL: (Name and Tele	ephone no.) (No collect calls) (313) 226-6	6421		DESTINATION (See Schedule)			
8. TO: NAME AND ADDRESS, INCLUDING ZIP CODE					ADMINIS ST. MAR	ESTINATION (Consignee and address, including ZIP Code) NISTRATIVE BRANCH ARY'S FALLS CANAL T STE. MARIE MI 49783 FAX:			
10. PLEASI	E FURNISH QU 19-Oct-2005	OTATIONS TO THI	E ISSUING OFFICE IN BLOC	CK 5a ON OR BEFO	DRE CLOSE	OF BUSINESS:			
IMPORTAN it to the address contract for su	s in Block 5a. This pplies or services.	request does not commi	uotations furnished are not offers. I t the Government to pay any costs i origin unless otherwise indicated b	ncurred in the preparati	ion of the subn	nission of this quotation or to			
		11. SC	HEDULE (Include applicabl	e Federal, State, an	ıd local taxe	es)			
ITEM NO.		SUPPLIES/ SE (b)	RVICES	QUANTITY (c)	UNIT (d)	UNIT PRICE (e)	- A	AMOUNT (f)	
	SEE	E SCHEDU	JLE						
12. DISCOU	JNT FOR PROM	MPT PAYMENT	a. 10 CALENDAR DAYS	b. 20 CALENDA	R DAYS	c. 30 CALENDAR DAYS		ENDAR DAYS	
NOTE: Ad	ditional provis	ions and represent	tations [] are [] are not	attached.	/0	1	% No.		
	AND ADDRESS	-	et, City, County, State, and			N AUTHORIZED TO	15. DAT QUO	TE OF OTATION	
				16. NAME AND T	TITLE OF S	IGNER (Type or print)		EPHONE NO. ide area code)	

Section B - Supplies or Services and Prices

ITEM NO SUPPLIES/SERVICES QUANTITY UNIT UNIT PRICE AMOUNT
0001 1 Lump Sum
REPAIR POE LOCK GATE CYLINDERS --FFP
IN ACCORDANCE WITH THE ATTACHED SCOPE OF WORK. PLEASE
CONTACT (313) 226-6421 FOR THE DRAWINGS.
PURCHASE REQUEST NUMBER: W56MES-5280-3059

NET AMT

FOB: Destination

Section C - Descriptions and Specifications

FY06-REPAIR POE LOCK GATE

Scope of Work Poe Lock Gate Cylinder Connection Parts

Background

The Poe Lock has three (3) sets of miter gates. Each gate set consists of two (2) gate leaves, which are numbered 1-North, 1-South, 2-North, 2-South, 3-North, and 3-South. These gate leaves are each operated by a hydraulic cylinder. The ends of each of these hydraulic cylinders are joined to the gate leaves by a gate connection assembly (see drawings D2-22/5 and D2-22/8). There are six (6) gate connection assemblies in total. These assemblies have been determined to be inconsistent with the specifications on the drawing. Specifically, the cylinder gate connection (22/5-4) on gate 3-North has failed at the welded joints. It was determined by visual inspection that this joint was inadequately welded, causing the failure. The remaining connections were ultrasonically tested on each gate and all were determined to be inadequately welded.

Work Required

The scope of this contract is to rebuild all six (6) of these gate connection assemblies, manufacture one (1) complete spare assembly, and manufacture one (1) cylinder gate connection (22/5-4).

Parts Supplied

The following new parts will be supplied by the Government:

- 3 ea Mark 22/8-Z Spherical Bearing
- 2 ea Mark 22/8-AC Shaft Seal
- 2 ea Mark 22/5-5 Bearing Retainer (refurbished)
- 1 ea Mark 22/5-9 Pin (refurbished)
- 1 ea Mark 22/5-11 Double Sleeve (refurbished)
- 1 ea Mark 22/5-12 Sleeve (refurbished)

Required Delivery Dates

The following items must be received by these dates. Note that five (5) of the original assemblies will not be available until after the lock shuts down on 15 January 2006. The availability is as follows: One (1) on 18 January 2006, one (1) on 20 January 2006, one (1) on 24 January 2006, one (1) on 26 January 2006, and the final one (1) on 30 January 2006.

15 November 2005

1 ea Rebuilt gate connection assembly1 ea New gate cylinder connection

17 January 2006

1 ea Spare gate connection assembly

2 February 2006

1 ea Rebuilt gate connection assembly

15 February 2006

2 ea Rebuilt gate connection assemblies

1 March 2006

2 ea Rebuilt gate connection assemblies

Specifications

Rebuilding Gate Connection Assemblies

The following specifications must be met on each of the parts when rebuilding the gate connection assemblies:

- 6 ea Mark 22/5-1 Flange
 - Refurbish original including sandblasting painted areas
 - Paint after assembly with Sherwin Williams V-103c black Vinyl Topcoat, or equivalent
- 6 ea Mark 22/5-2 Retaining Ring
 - Refurbish originals
- 6 ea Mark 22/5-3 Keeper Plate
 - Refurbish and sandblast original
 - Paint after assembly with Sherwin Williams V-103c black Vinyl Topcoat, or equivalent
- 6 ea Mark 22/5-4 Cylinder Gate Connection (Option 1)
 - Refurbish original by removing all welds and reweld in accordance to AWS D1.1 Table C8.1 (for ASTM A373), supplying weld procedure for review beforehand (welds will be ultrasonically tested before part is accepted)
 - Sandblast painted areas
 - Build up holes with weld and rebore
 - Paint with Sherwin Williams V-103c black Vinyl Topcoat, or equivalent
- 6 ea Mark 22/5-4 Cylinder Gate Connection (Option 2)
 - Manufacture new from ASTM A36 Structural Steel and weld in accordance to AWS D1.1, supplying weld procedure for review beforehand (welds will be ultrasonically tested before part is accepted)
 - Paint with Sherwin Williams V-103c black Vinyl Topcoat, or equivalent
- 10 ea Mark 22/5-5 Bearing Retainer
 - Refurbish original including sandblasting painted areas
 - Paint after assembly with Sherwin Williams V-103c black Vinyl Topcoat, or equivalent
- 12 ea Mark 22/5-6 Cover Gasket
 - Supply new
- 6 ea Mark 22/5-7 Cover
 - Refurbish original including sandblasting painted areas
 - Paint after assembly with Sherwin Williams V-103c black Vinyl Topcoat, or equivalent
- 6 ea Mark 22/5-8 Cover
 - Refurbish original including sandblasting painted areas
 - Paint after assembly with Sherwin Williams V-103c black Vinyl Topcoat, or equivalent
- 5 ea Mark 22/5-9 Pin
 - Refurbish original including sandblasting painted areas
 - Build up diameter with weld and turn in lathe
 - Paint top cap after assembly with Sherwin Williams V-103c black Vinyl Topcoat, or equivalent
- 6 ea Mark 22/5-10 Flanged Eye
 - Refurbish original including sandblasting painted areas

- Paint after assembly with Sherwin Williams V-103c black Vinyl Topcoat, or equivalent
- 5 ea Mark 22/5-11 Double Sleeve
 - Manufacture new from ASTM A36 Structural Steel
- 5 ea Mark 22/5-12 Sleeve
 - Manufacture new from ASTM A36 Structural Steel
- 96 ea Mark 22/8-C Hex Head Cap Screw
 - Supply new
- 72 ea Mark 22/8-M Hex Head Cap Screw
 - Supply new
- 96 ea Mark 22/8-V Hex Head Cap Screw
 - Supply new
- 96 ea Mark 22/8-W Flat Head Cap Screw
 - Supply new
- 72 ea Mark 22/8-X Heavy Hex Bolts and Nuts
 - Supply new
- 144 ea Mark 22/8-Y Plain Washer
 - Supply new
- 3 ea Mark 22/8-Z Spherical Bearing
 - Supply new
- 6 ea Mark 22/8-AA O-ring
 - Supply new
- 12 ea Mark 22/8-AB O-ring
 - Supply new
- 10 ea Mark 22/8-AC Shaft Seal
 - Supply new
- 6 ea Mark 22/8-AE Hex Head Cap Screw
 - Supply new
- 6 ea Mark 22/8-AV Alemite Fitting
 - Supply new

Spare Assembly

The following specifications must be met on each of the parts when manufacturing the spare gate connection assemblies:

- 1 ea Mark 22/5-1 Flange
 - Manufacture new from ASTM A148 Grade 90-60 High Strength Steel Casting
 - Paint after assembly with Sherwin Williams V-103c black Vinyl Topcoat, or equivalent
- 1 ea Mark 22/5-2 Retaining Ring
 - Manufacture new from ASTM A276 Type 304 Stainless Steel
- 1 ea Mark 22/5-3 Keeper Plate
 - Refurbish original including sandblasting painted areas
 - Paint after assembly with Sherwin Williams V-103c black Vinyl Topcoat, or equivalent
 - Paint with Sherwin Williams V-103c black Vinyl Topcoat, or equivalent
- 2 ea Mark 22/5-5 Bearing Retainer
 - Refurbish original including sandblasting painted areas
 - Paint after assembly with Sherwin Williams V-103c black Vinyl Topcoat, or equivalent
- 2 ea Mark 22/5-6 Cover Gasket
 - Supply new
- 1 ea Mark 22/5-7 Cover

- Manufacture new from ASTM A36 Structural Steel
- Paint after assembly with Sherwin Williams V-103c black Vinyl Topcoat, or equivalent
- 1 ea Mark 22/5-8 Cover
 - Manufacture new from ASTM A36 Structural Steel
 - Paint after assembly with Sherwin Williams V-103c black Vinyl Topcoat, or equivalent
- 1 ea Mark 22/5-9 Pin
 - Refurbish original including sandblasting painted areas
 - Build up diameter with weld and turn in lathe
 - Paint top cap after assembly with Sherwin Williams V-103c black Vinyl Topcoat, or equivalent
- 1 ea Mark 22/5-10 Flanged Eye
 - Manufacture new from ASTM A148 Grade 80-40 High Strength Steel Casting
 - Paint after assembly with Sherwin Williams V-103c black Vinyl Topcoat, or equivalent
- 1 ea Mark 22/5-11 Double Sleeve
 - Manufacture new from ASTM A36 Structural Steel
- 1 ea Mark 22/5-12 Sleeve
 - Manufacture new from ASTM A36 Structural Steel
- 16 ea Mark 22/8-C Hex Head Cap Screw
 - Supply new
- 12 ea Mark 22/8-M Hex Head Cap Screw
 - Supply new
- 16 ea Mark 22/8-V Hex Head Cap Screw
 - Supply new
- 16 ea Mark 22/8-W Flat Head Cap Screw
 - Supply new
- 1 ea Mark 22/8-Z Spherical Bearing
 - Supply new
- 1 ea Mark 22/8-AA O-ring
 - Supply new
- 2 ea Mark 22/8-AB O-ring
 - Supply new
- 2 ea Mark 22/8-AC Shaft Seal
 - Supply new
- 1 ea Mark 22/8-AE Hex Head Cap Screw
 - Supply new
- 1 ea Mark 22/8-AV Alemite Fitting
 - Supply new

Gate Cylinder Connection

The following specifications must be met on each of the parts when manufacturing the gate cylinder connection:

- 1 ea Mark 22/5-4 Cylinder Gate Connection
 - Manufacture new from ASTM A36 Structural Steel and weld in accordance to AWS D1.1, supplying weld procedure for review beforehand (welds will be ultrasonically tested before part is accepted)
 - Paint with Sherwin Williams V-103c black Vinyl Topcoat, or equivalent
- 12 ea Mark 22/8-X Heavy Hex Bolts and Nuts
 - Supply new
- 24 ea Mark 22/8-Y Plain Washer
 - Supply new

Page 7 of 10

Section E - Inspection and Acceptance

INSPECTION AND ACCEPTANCE

Supplies/services will be inspected/accepted at:

CLIN	INSPECT AT	INSPECT BY	ACCEPT AT	ACCEPT BY
0001	N/A	N/A	N/A	N/A

Section F - Deliveries or Performance

DELIVERY INFORMATION

CLIN	DELIVERY DATE	QUANTITY	SHIP TO ADDRESS	UIC
0001	15-NOV-2005	1	ADMINISTRATIVE BRANCH ST. MARY'S FALLS CANAL SAULT STE. MARIE MI 49783 FOB: Destination	

Section G - Contract Administration Data